Work Order ID 80009 *80009*

February-08-12 4:06:14 PM

Item ID: D2230-3 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Lug

Start Date: 08/02/2012 **Start Qty:** 200.00 *200* **Cust Item ID:**

Required Date: 22/02/2012 **Req'd Qty:** 200.00 *200* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** M.C.J **Date:** 12/02/08 **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2230	Rev G

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Insp.
100 *100* Bandsaw Jeaspa Bandsaw	BAND SAW **Memo** Cut D2423 extrusion to 0.82" Batch:________ Cut @ Imetec	0.00 0.00	CL 12/02/10
110 *110* HAAS 1 Quench. HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 **Memo** 1-Machine per folio FA927 FOLIO REV:________ DWG REV:________ Check for crack while loading into the machine. 2- deburr	0.00 0.00	CL 12/02/10 200

issued P/O to Imetec P/O: 1667

machine as per dwg D 2230 REV. G

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes No **DQA:** _____ **Date:** ______

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80009

February-08-12 4:06:14 PM

80009

Item ID: D2230-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Lug

Start Date: 08/02/2012 **Start Qty:** 200.00 *200* **Cust Item ID:**

Required Date: 22/02/2012 **Req'd Qty:** 200.00 *200* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 rec'd *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				12/3/9		200	
	Memo rec'd + inspect for transit damage attached c of c to w/o	0.00							
130 *130* QC Quality Control	QC8- Inspect parts - second check	0.00							
	Memo	0.00 S. 2/03/12				(x200)			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				200	0	AP	12/03/05
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 80009 *80009*

February-08-12 4:06:14 PM

Item ID:	D2230-3	**Accept**	*N900040100*	**Setup Start**	*NS1*
Revision ID:				**Stop**	*NS2*
Item Name:	Lug				
Start Date:	08/02/2012	**Start Qty:** 200.00	*200*	**Cust Item ID:**	
Required Date:	22/02/2012	**Req'd Qty:** 200.00	*200*	**Customer:**	
Reference:					

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ____________ **Date:** ________ **Run Start** *NR1*

QC: ____________ **Date:** ________ **SPC (Y/N):** ____________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00				200	BK		12-3-5
	Memo	0.00							
170 *170* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				200	0		(stamp) 12/03/07
	Memo START TIME: 8h05 OVEN TEMPERATURE: 320°F FINISH TIME: 8h35	0.00							
180 *180* QC Quality Control	QC3- Inspect Part Finish	0.00				200	0		JH 12/03/08
	Memo	0.00							

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 80009

February-08-12 4:06:14 PM

80009

Item ID: D2230-3
Revision ID:
Item Name: Lug
Start Date: 08/02/2012 **Start Qty:** 200.00 *200*
Required Date: 22/02/2012 **Req'd Qty:** 200.00 *200*
Reference:

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 480	0.00				12/3/8			200
190 Packaging	**Memo**	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00				12/3/8			
200 QC	**Memo**	0.00							
Quality Control									

12-03-8

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ PAR #: ______ Fault Category: ________ NCR: Yes No DQA: _____ Date: ________

Resolution: ________ Disposition: ________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-08-12 4:06:19 PM

Work Order ID: 80009 *80009*

Parent Item: D2230-3 *D2230-3*

Parent Item Name: Lug

Start Date: 08/02/2012 **Required Date:** 22/02/2012

Start Qty: 200.00 **Required Qty:** 200.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder coatEC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P *D2230-3P* LUG		Purchased	No				Each	200.0000	**	200	C 12/3/2 (200)		
D2423 *D2423* Lug Extrusion		Manufactured	No			100	f	373.9000	0.0683 **	14.37895	CL 12/02/10		

D2230-3P locations:

Location		Loc Qty	Loc Code	
ST		200		
	78953	200		

D2423 locations:

Location		Loc Qty	Loc Code	
MAT006		373.9		
	43722	161.5		
	45800	1		
	68331	211.4		14.39

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	80009
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.450	✓		Vern	ED-6
0.413	+/-0.010	0.420			Vern	ED-6
0.306	+/-0.010	0.313	✓		Vern	ED-6
3.700	+/-0.010	3.699			Vern	ED-6
0.750	+/-0.010	0.760	✓		Vern	ED-6
Ø0.257	+0.005/-0.000	0.257	✓		Vern	ED-6
0.375	+/-0.010	0.373	✓		Vern	ED-6
R1.200	+/-0.010	1.20	✓		R-G	
0.100 x 45°	+/-0.010	0.100"x45°	✓		Ver	

Measured by:	N/A
Date:	

Audited by:	[signature]
Date:	12/3/22

Preliminary Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	
B	10.08.03	Dimensions updated per Dwg Rev G	KJ [signature]	[signature]

Dart Aerospace Ltd

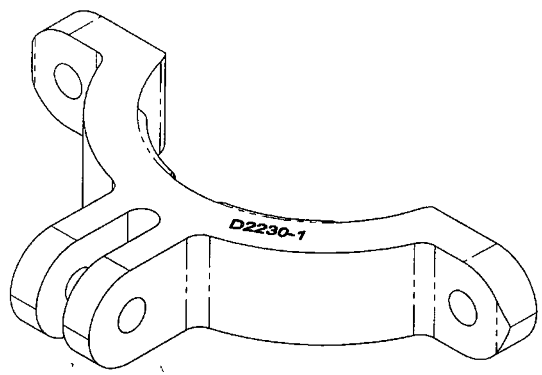
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

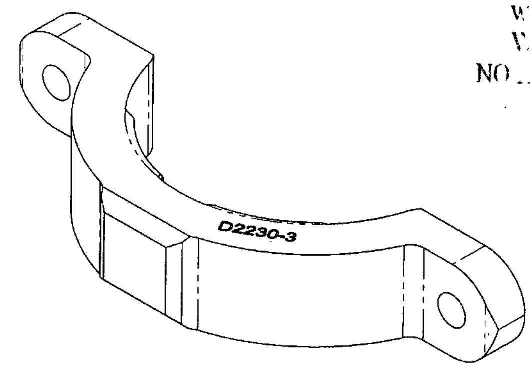
Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHO... RE... ENG... UNCONTR... SUBJECT... WIT... NO.. 80009 M.C.J 12/02/08

RELEASED 09/06/25

G

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

REV.	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2230 — REV. G — SHEET 1 OF 3
MFG. APPR.		
APPROVED		TITLE MOUNTING LUG — SCALE NTS
DE APPR.		
DATE	09.01.16	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

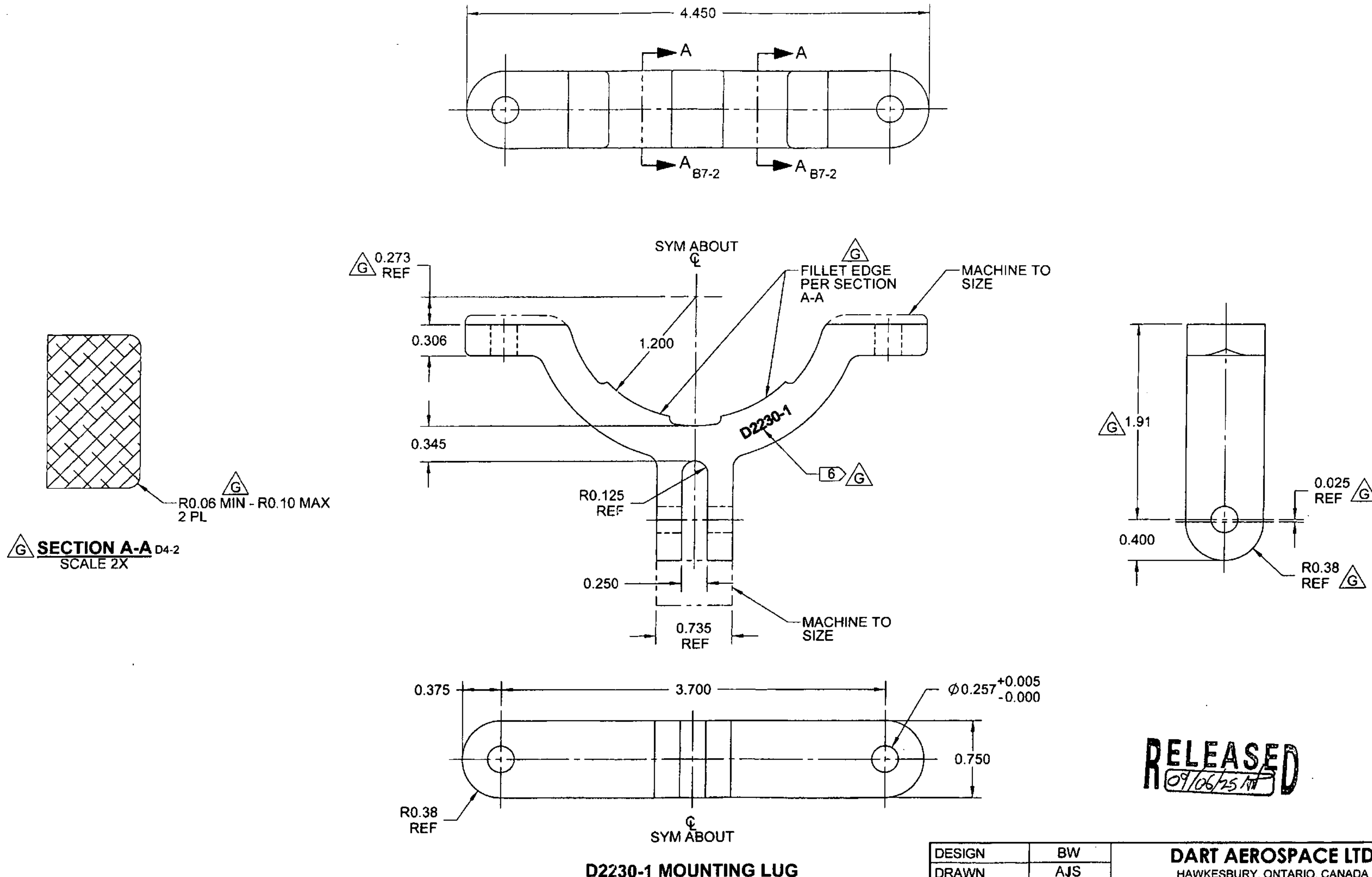
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

80009



D2230-1 MOUNTING LUG

RELEASED 09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2230 — REV. G — SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE MOUNTING LUG — SCALE NTS
DE APPR.		
DATE	09.01.16	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

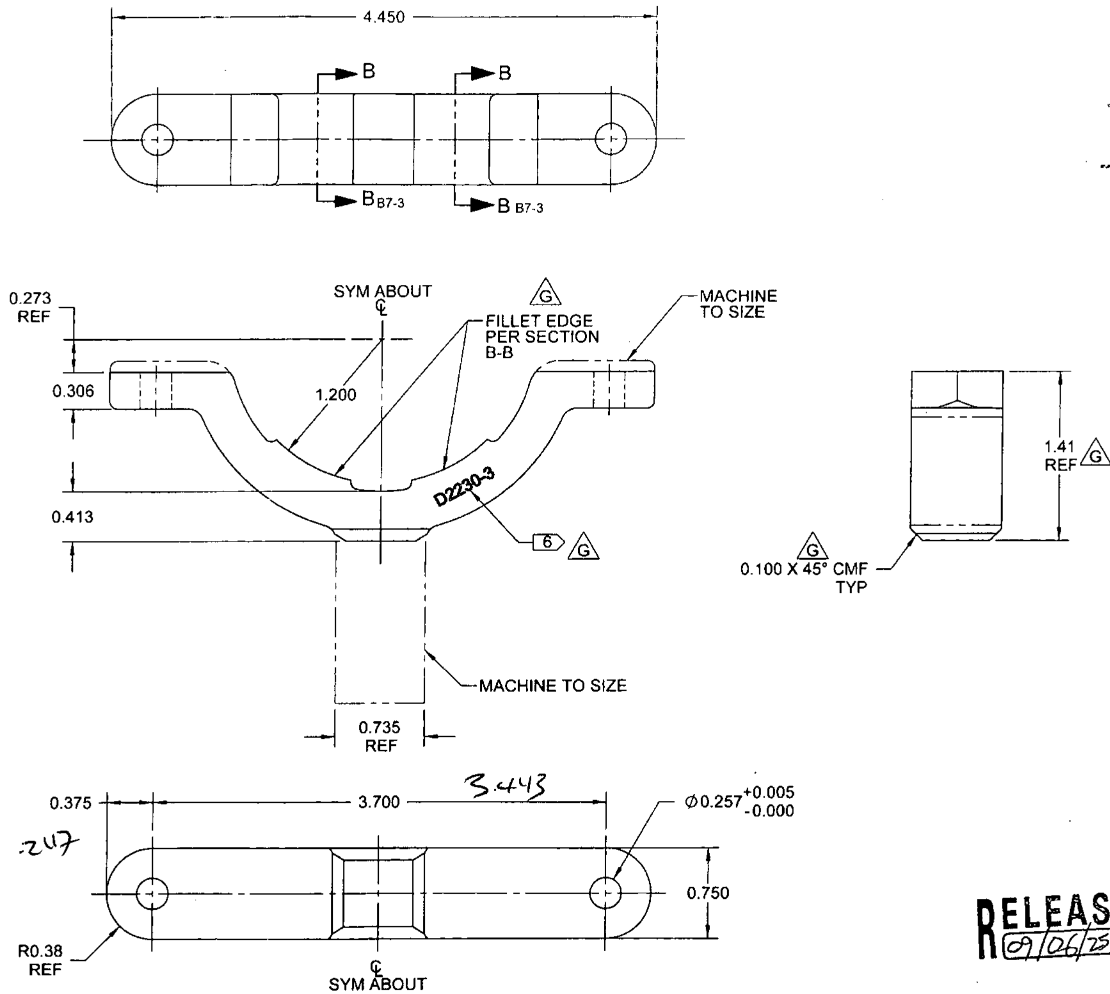
Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

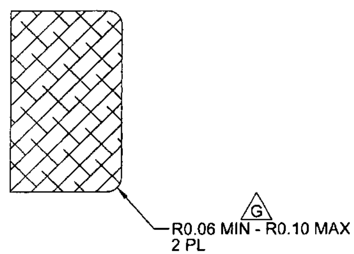
Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

80009





SECTION B-B D4-3
SCALE 2X

D2230-3 MOUNTING LUG

RELEASED 09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	DRAWING NO. D2230 — REV. G — SHEET 3 OF 3
CHECKED		
MFG. APPR.		
APPROVED		TITLE MOUNTING LUG — SCALE NTS
DE APPR.		
DATE	09.01.16	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16167

Purchase Order Date 2/10/12
PO Print Date 2/10/12

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 12/02/10

Line Nbr	Reference / Revision ID / Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	2/29/12 Yes	160.00 Each	Yours ppd	$18.9500	$3,032.00
		Special Inst: AS PER DWG D2230 REV. G B80008					
2	D2230-3P	LUG	2/29/12 Yes	200.00 Each	Yours ppd	$13.6000	$2,720.00
		Special Inst: AS PER DWG D2230 REV. G B80009					

12/3/2

PO Total: $5,752.00

CERTIFICATE OF CONFORMITY

CL

W

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1 **Change Date:** 2/10/12

METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18451**
Date: Feb 29, 2012
Page: 1

Sold to:	**Ship to:**
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16167	**Sold By:** Dewar, Eric
Shipped By: your truck	**Ship Date:**

	Description	**Unit**	**Ordered quantity**	**Shipped quantity**	**Backorder quantity**
D2230-1	Mounting Lug as per dwg. D2230 REV.G B80008	Each	160		160
D2230-3	Mounting Lug as per dwg. D2230 REV.G B80009	Each	200	200	

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by ____________________

Thank you for your order!

METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
200	D2230-3	Lug	16167

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, February 29, 2012